

Work Order ID 69156

Tuesday, May 03, 2011 1:35:26 PM



Page 1

Item ID:	D3916-5	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Light Rib					
Start Date:	5/3/2011	Start Qty: 9.00		Cust Item ID:		
Required Date:	5/17/2011	Req'd Qty: 9.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-05-3	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- Cut tube 50"								
	2- Bend tube with manuel pipe bender as per DT9566								
	*** Make line at 9.00" annd use jig for other line***								
	3- Trim access tube material to finish size as per dwg D3916								
110	QC6- Inspect dimensions to drawing	0.00							
	QC								
Quality Control	Memo	0.00							
120	Identify as per dwg & Stock Location:	0.00							
	Packaging								
Packaging	Memo	0.00							

SFD
11-05-20

PL 11.05.20

PL 11.05.20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69156

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Item ID: D3916-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Light Rib

Start Date: 5/3/2011 Start Qty: 9.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 9.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/24

MUF
11-05-20

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 1:35:32 PM

Page 1

Work Order ID: 69156

Parent Item: D3916-5

Parent Item Name: Light Rib



Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.500W.049

Purchased

No

100

f

85.4048

4.166

39.46737



Square Tubing



SAD 11-05-20

Location

Loc Qty

Loc Code

MAT034

85.4048

116610

0.8383

117314

84.5665

131546

m11721

26.3128

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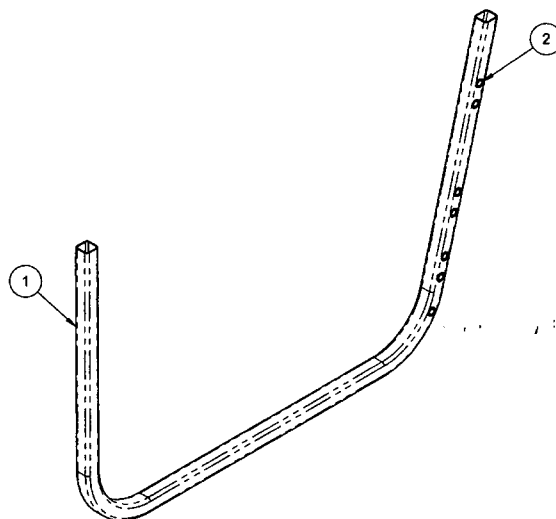
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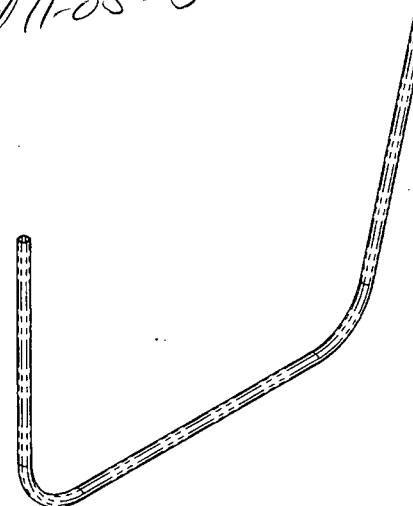
NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69156
11-05-3



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

OK 10.12.21
~~UNDER REVIEW~~
10.10
ADDITION OF HOLE + BUSHING
on D3916-041-1 RIBS.

RELEASED
2010-03-12
JMP

REV.	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS		BY	DATE
DRAWN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916		REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE		SHEET 1 OF 4
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET		SCALE NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

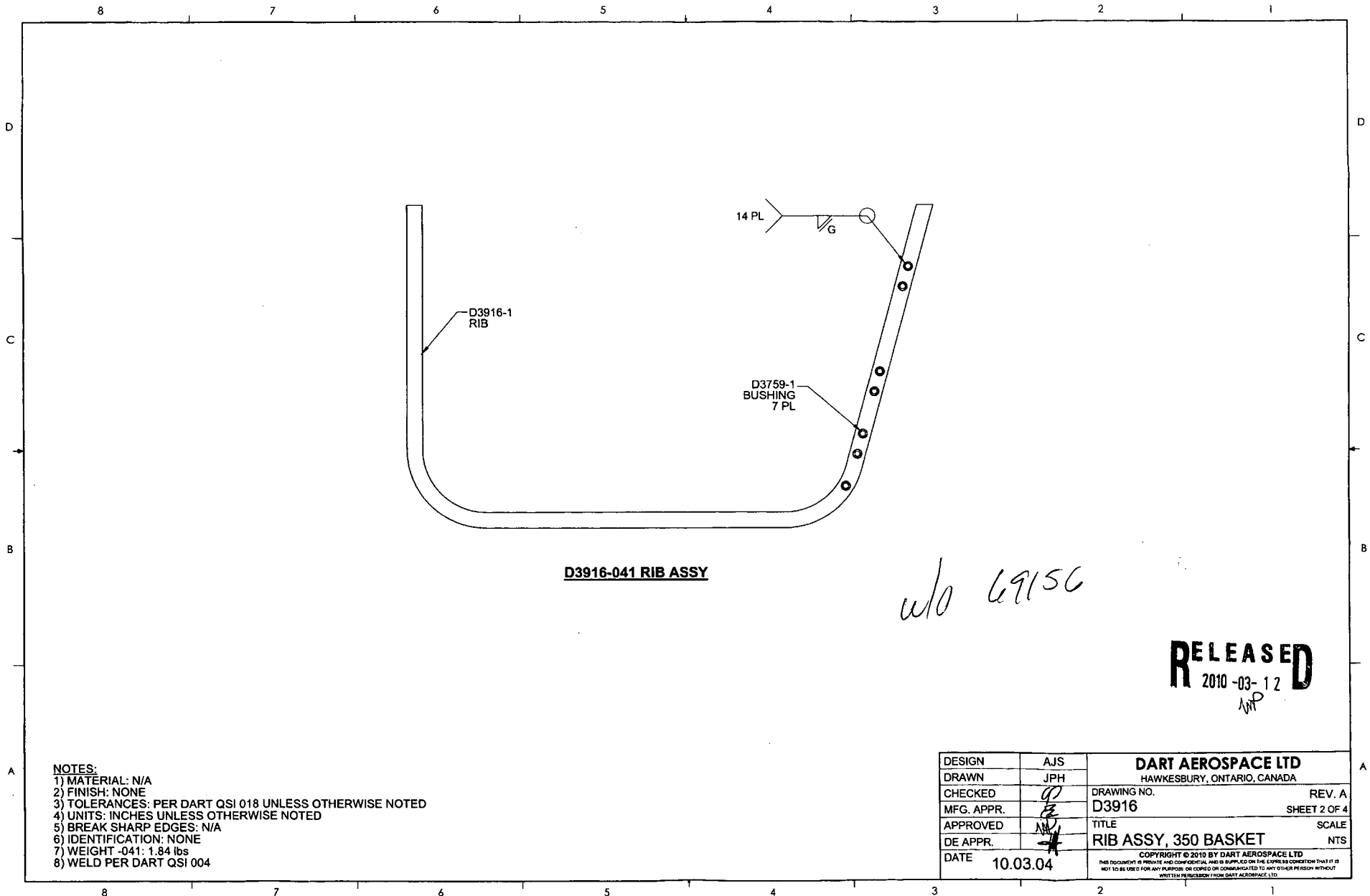
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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2010-03-12
ANT

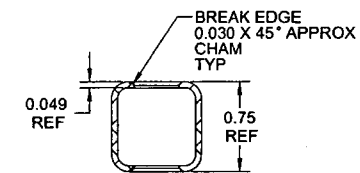
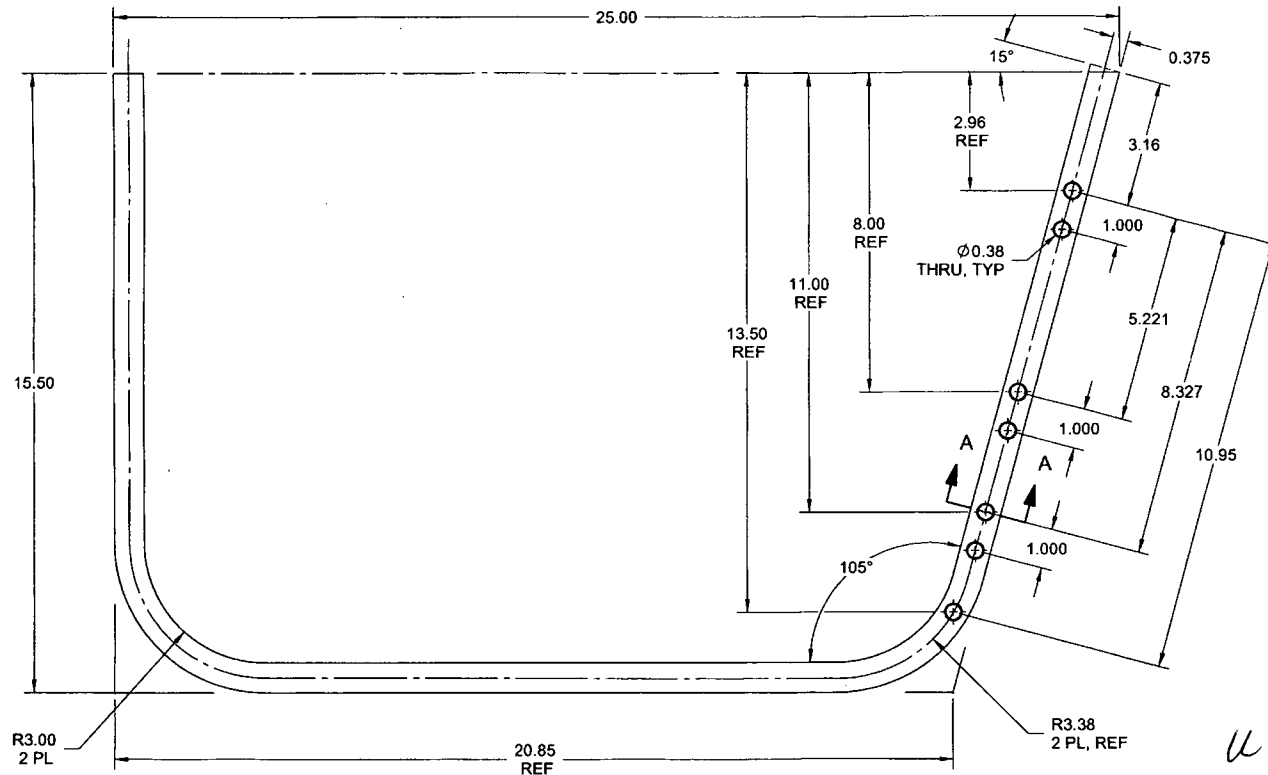
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







SECTION A-A

9 D3916-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

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CHECKED		DRAWING NO.	REV. A
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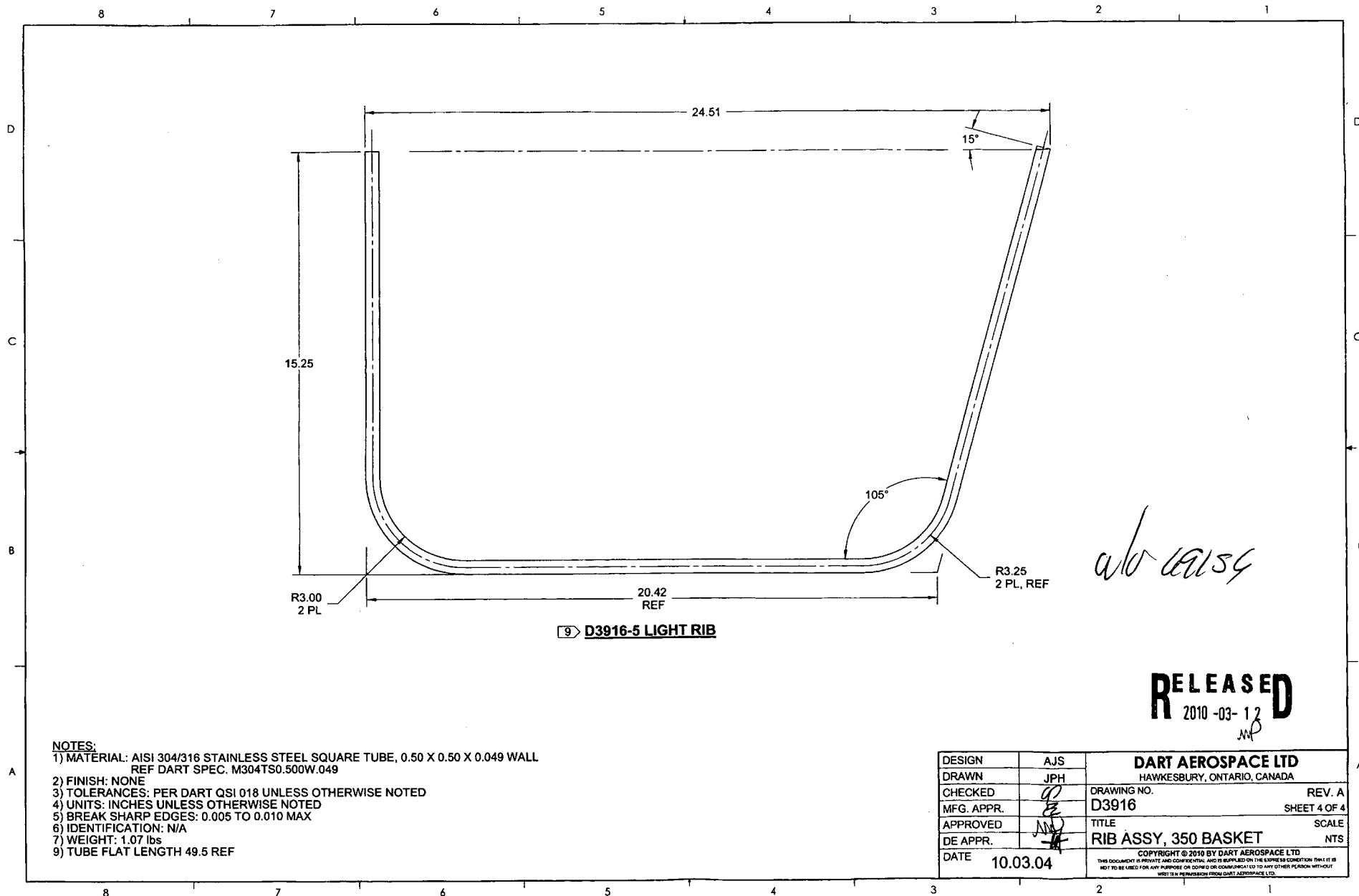
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




W/O 19154

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

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2010-03-12
ANB

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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